

Work Order ID 74524

Monday, October 03, 2011 4:03:16 PM



Page 1

Item ID: D3294-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: ML-J

Date: 11/10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

Dwg Rev: C

Prog Rev: L

2024.080

****grain direction as per dwg D3294 ****

2-Deburr if necessary

B1-10-28

SC

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B1-10-2C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				counts (720)			
130 Brake NC Brake NC	Memo 1- Deburr if necessary 2- Bend as per Dwg D3294	0.00 0.00				(20)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				counts (720)			

8 u/10/22

SB 11/11/10

8 u/11/10

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Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							20XJ M-11/11/10
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							20 BL 11-11-10
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>STGA</u> Memo	0.00 0.00							SP 11-11-10

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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/14 *[Signature]*
[Signature]
11-11-11

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Picklist Print

Page 1

Monday, October 03, 2011 4:03:22 PM

Work Order ID: 74524



Parent Item: D3294-5



Parent Item Name: Doubler



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	245.3000	0.065	0.821053	1.5		
													
2024-T3 .080 sheet													

B.11-10-26

Location

Loc Qty

Loc Code

MAT022

245.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

67.2

119117

96

118180



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DART AEROSPACE LTD		Work Order: 74524
Description: Doubler		Part Number: D3294-5
Inspection Dwg: D3294	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	✓		V BGL	
0.65	+/-0.030	.65	✓		V	
0.30	+/-0.030	.297	✓		V	
0.53	+/-0.030	.53	✓		V	
3.36	+/-0.030	3.355	✓		V	
2.50	+/-0.030	2.494	✓		V	
0.15	+/-0.030	.153	✓		V	
9.21	+/-0.030	9.214	✓		PROWSON	
0.400	+/-0.010	.400	✓		V	
0.300	+/-0.010	.303	✓		V	
0.30	+/-0.030	.301	✓		V	
0.625	+/-0.010	.626	✓		V	
0.080	+/-0.010	.079	✓		V	
1.00	+/-0.030	1.006	✓		V	

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 11-10-26	Date: 4/40/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

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ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 74524 M.L.J.

11/10/04

RELEASED
09/07/07 JH

D3294-1 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.05.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3294** REV. C
TITLE **BRACKET** SCALE NTS
SHEET 1 OF 6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

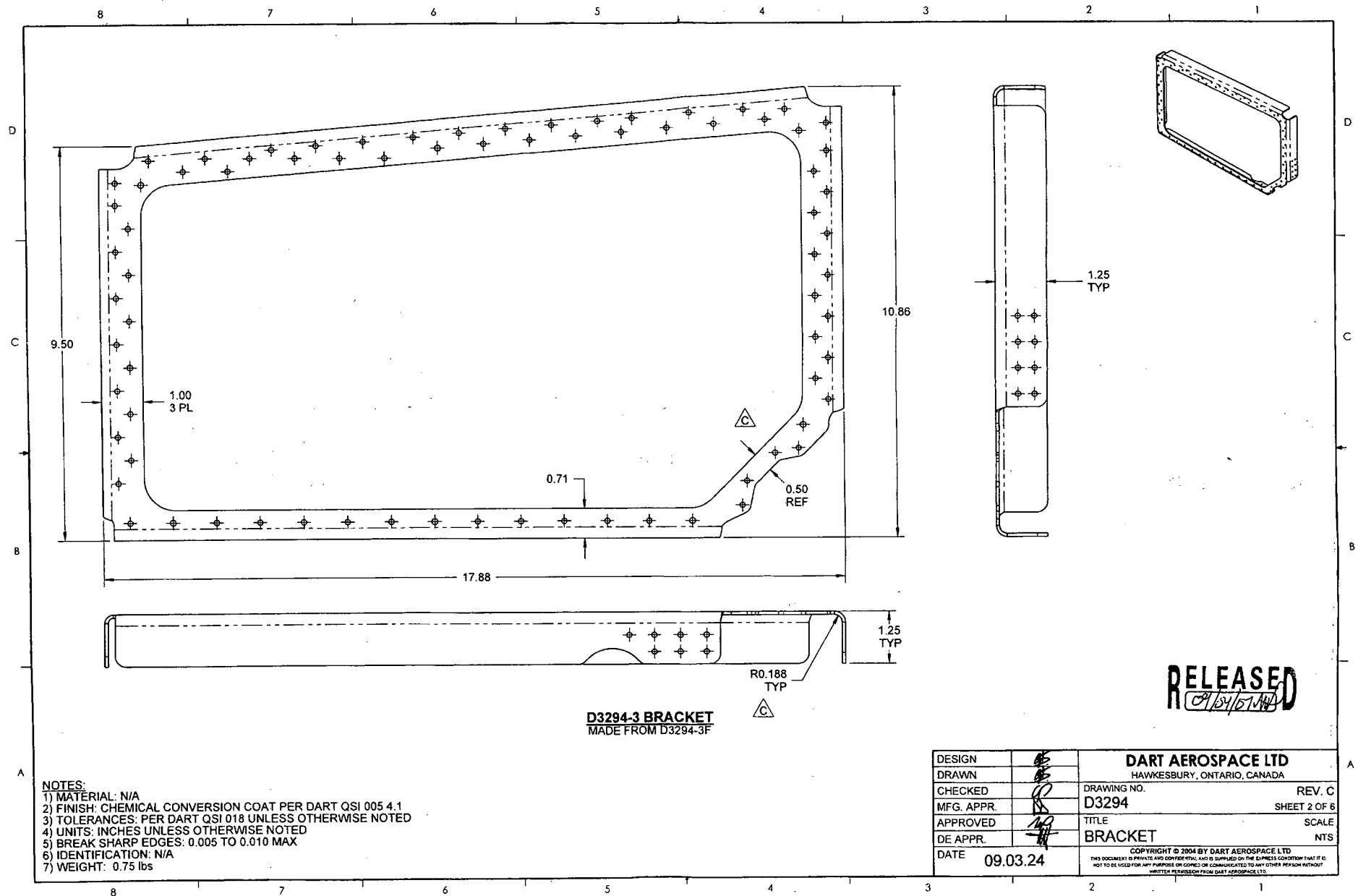
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NOTE: Date & initial all entries

74524



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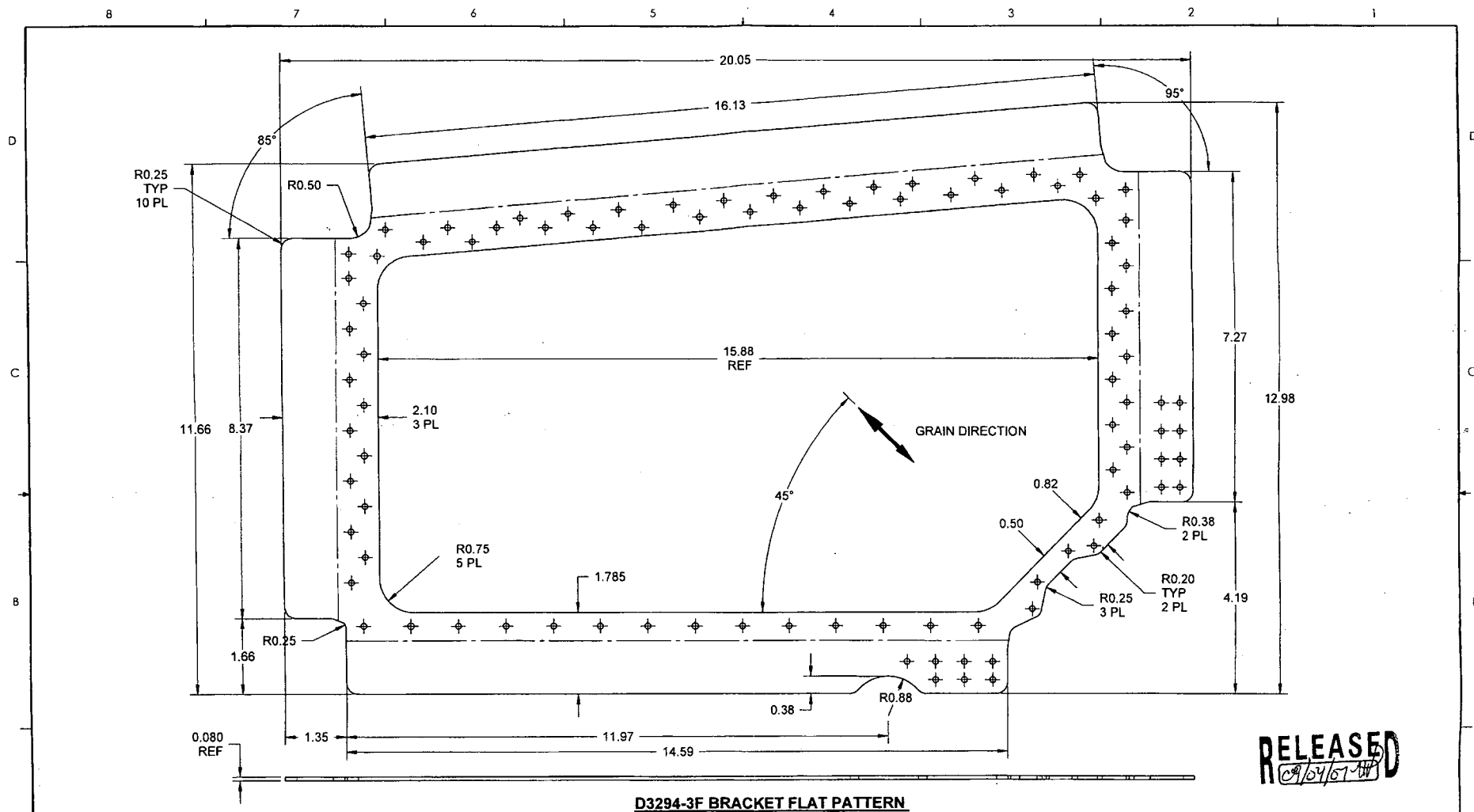
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74524



D3294-3F BRACKET FLAT PATTERN

RELEASED
CA/64/61-W

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D3294	SHEET 3 OF 6
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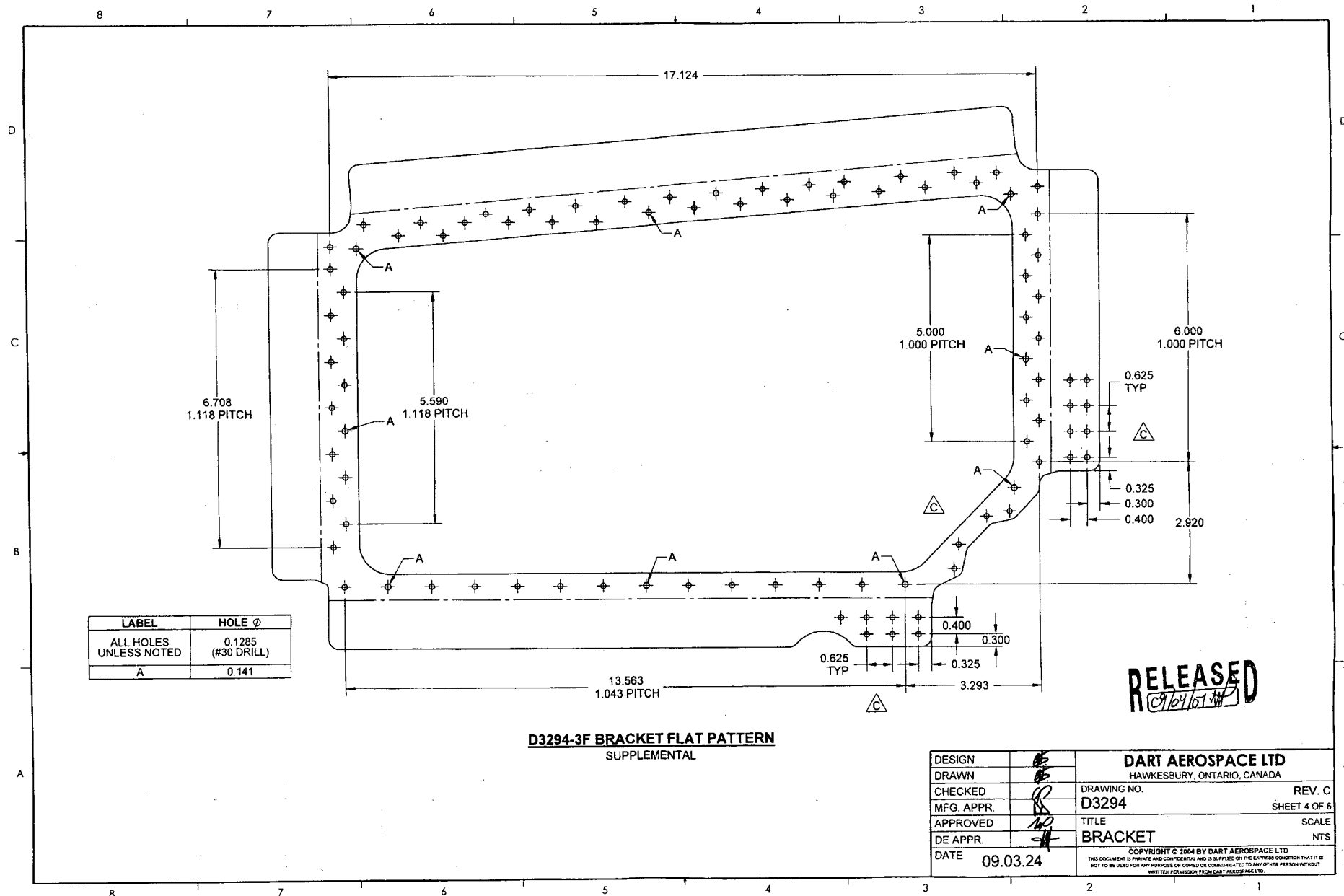
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74524



RELEASED
09/04/01

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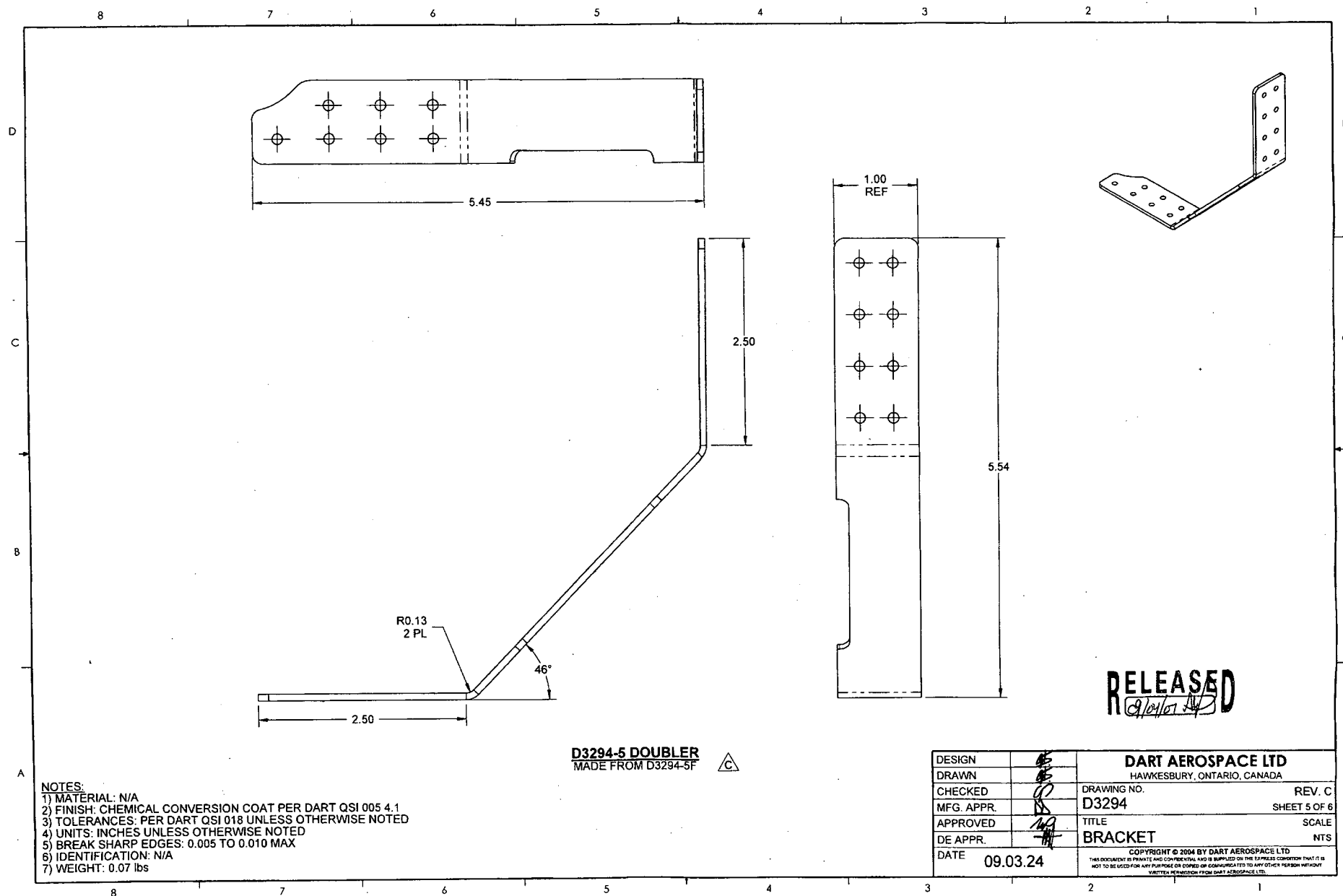
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NOTE: Date & initial all entries

74524



RELEASED
9/10/01

D3294-5 DOUBLER
MADE FROM D3294-5F

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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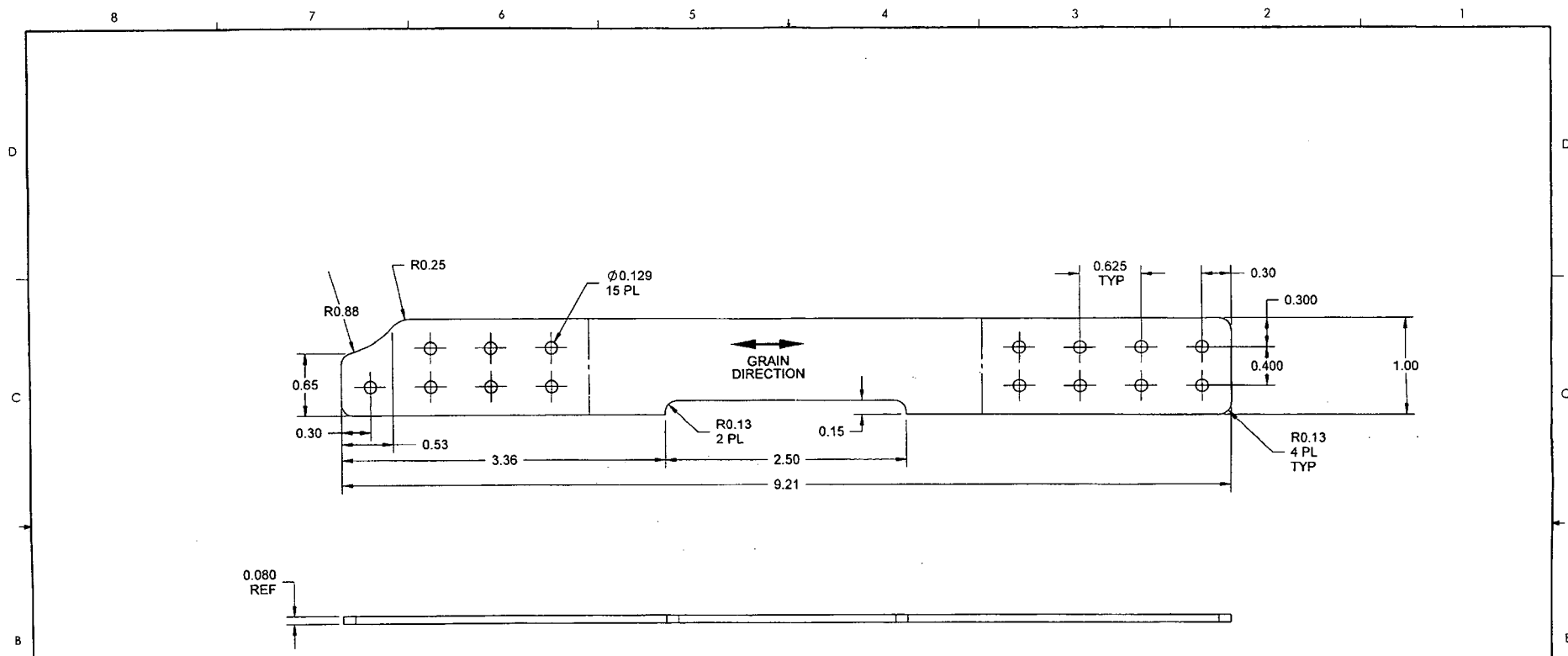
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




74524



D3294-5F DOUBLER FLAT PATTERN 

RELEASED
09/04/07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.07 lbs

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